

Work Order ID 56348

Thursday, February 18, 2010 12:08:55 PM

Page 1

Item ID: D3267-043

Accept

Revision ID:

Item Name: Basket Lid Assembly (Inside)

Start Date: 2/19/2010 Start Qty: 1.00

Required Date: 2/25/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: MF

Date: 10-2-18

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3267

Rev C

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut Rib from 3/4" x 3/4" x 0.063" wall 304/316 SS tubing as per Dwg D3267
2-Cut (4) D2236-1 From D3166-3 3-Drill holes in tubing D3267-043
as per Dwg D3267 4-Deburr & Remove All Markings From Material 5-Weld
D3267-043 Assembly using Welding Table and

10.02.25

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

10.02.25

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

8.01.25

fl

W/O:		WORK ORDER CHANGES					
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Setup Start

Revision ID:

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Stop

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

1ST START TIME: 10:00am OVEN TEMPERATURE:

10:30am FINISH TIME:

400°F ***** 2nd coat if

necessary ***** 2ND COAT START TIME:

11:30am OVEN TEMPERATURE: 400°F

140

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

145

ID and Stock B 56345

150

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

EP 10/03/03 @
EP 10/03/03 @

10/03/11
mf
10-3-4

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Picklist Print

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Work Order ID: 56348

Parent Item: D3267-043

Parent Item Name: Basket Lid Assembly (Inside)



Start Date: 2/19/2010

Required Date: 2/25/2010



Comments: IPP Rev:C Removed -041 05-11-04 JLM
IPP Rev:D 08-09-10 revC as per dwg (ecn 08-524) DD verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3166-3		Manufactured	No			100	Each	14.0000	0.0000			
										SAD	10-02-23	
Basket Hoop												

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
ST	5	
48429	5	
Main Warehouse		
WA	9.000014474	
52058	1.4474E-05	
54018	3	
55697	6	

D3182-1	Manufactured	No	100	Each	8.0000	2.0000
						
Hinge						

Warehouse	Loc Qty	Loc Code
<u>Location</u>		
Main Warehouse		
WA	8	
53445	8	

SAD 10-02-23

2

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3442-3		Manufactured	No			100	Each	4.0000	2.0000			



Shim



SAD 10-02-23

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

ST	4	
42718	1	
53137	3	

M304EX0.75-16F

Purchased

No

110 sf

1,072.652 4.5263



SAD 10-02-23

Expanded Metal Flat SS

Warehouse Location	Loc Qty	Loc Code
-----------------------	---------	----------

Main Warehouse

MAT	1072.652006	
111956	0.000017	
112147	9.4736E-06	
112949	32.58138	
113205	0.0093	
113497	0.1449	
113555	773.4991	
113904	266.4173	

4.5263

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Shop Packet Print

Page 2

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Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304TS0.750W.065		Purchased	No			100	f	448.7902	7.3684			
										SAD	10-02-23	
304 SQ Tube .75x.75x.065W												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

448.7901712

113082

0.00419

113245

0.00038421

113683

16.30855

113836

52.477047

113956

380

Main Warehouse

WA

0.0000047

112398

0.0000047

4.00
3.3685

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Page 3

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QTY -041	QTY -043	PART NUMBER	DESCRIPTION
X		D3267-041	BASKET LID ASSEMBLY (OUTSIDE)
	X	D3267-043	BASKET LID ASSEMBLY (INSIDE)
2		D2327-3	SPACER BUSHING
1		D2506	LABEL PLATE
1		D2512-7	STRUT
2		D2581	MOUNTING BRACKET
	1	D2989-1	STRUT
	1	D2989-2	STRUT
	1	D2989-3	STRUT
	1	D2989-4	STRUT
	2	D2989-5	STRUT
	2	D2989-7	STRUT
1		D2989-9	STRUT
1		D2989-10	STRUT
1		D2989-11	STRUT
1		D2989-12	STRUT
2		D2989-13	STRUT
2		D2989-15	STRUT
	2	D3182-1	HINGE
2	2	D3265-3	STRUT
1		D3266-7	STRUT
2		D3267-1	STRUT
	2	D3442-3	SHIM

\$56348

RELEASED
08.08.15



NOTES:

- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
(D2989-3/4/5/11/12/13 CAN BE MADE FROM D2236)
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3.
BLACK ANTI-SKID PAINT INDICATED AREA PER DART QSI 005 4.4.
SPRAY PAINT INSIDE SURFACE BLACK PRIOR TO APPLYING ANTI-SKID.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

C	DRAWING UPDATED TO CURRENT STANDARDS. SHEET 3 ADDED. FRAME MATERIAL WALL THICKNESS WAS 0.060. D3267-1 DETAILED.	AJS	08.08.15
B	ADD SHIM UNDER HINGES	PH	05.06.08
A	NEW ISSUE	DS	04.02.02
REV.	DESCRIPTION	BY	DATE
DESIGN	DS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS	DRAWING NO.	REV. C
CHECKED	PH	D3267	SHEET 1 OF 3
MFG. APPR.	DS	TITLE	SCALE
APPROVED	PH	BASKET LID ASSEMBLY	NTS
DE APPR.	PH	DATE 08.08.15	
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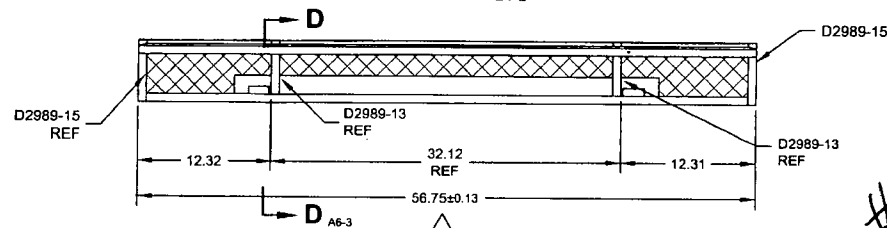
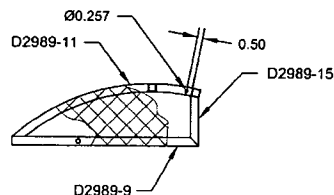
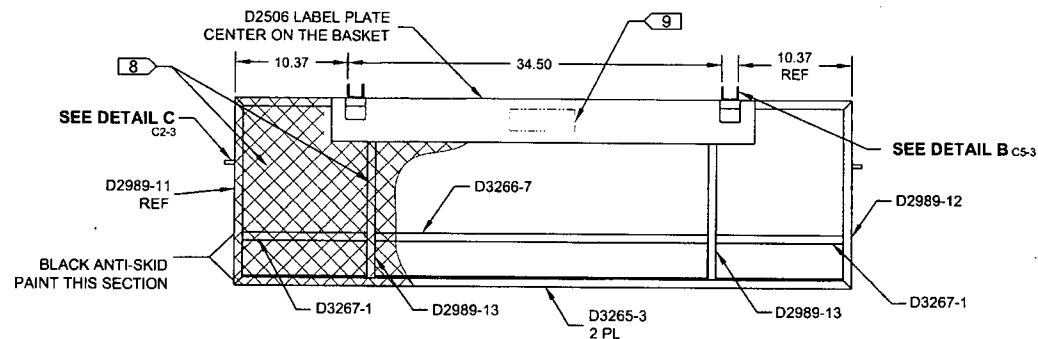
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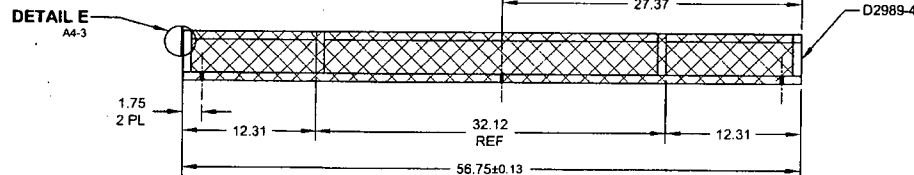
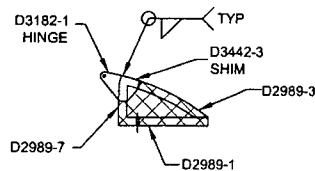
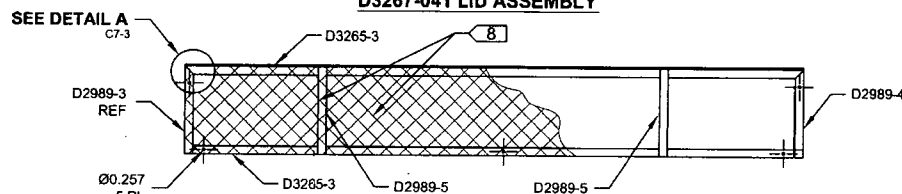
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



56348

D3267-041 LID ASSEMBLY



RELEASED
08.09.04/17



NOTES:

- 1) MATERIAL: SEE SHEET 1
- 2) FINISH: SEE SHEET 1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) SKIN WITH EXPANDED STEEL MESH. TACK WELD MESH TO FRAME AT EVERY AVAILABLE LOCATION.
- 9) REMOVE 2" x 6" SECTION OF MESH FROM BEHIND LABEL PLATE

D3267-041 LID ASSEMBLY

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	AS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3267	2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

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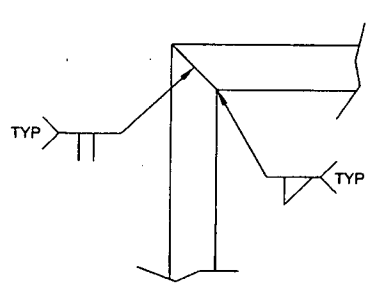
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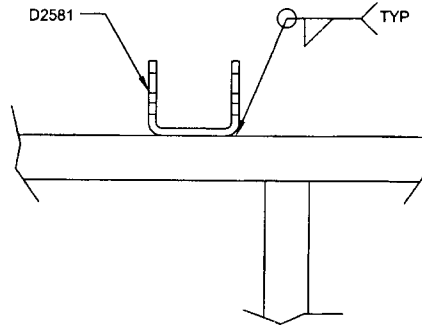
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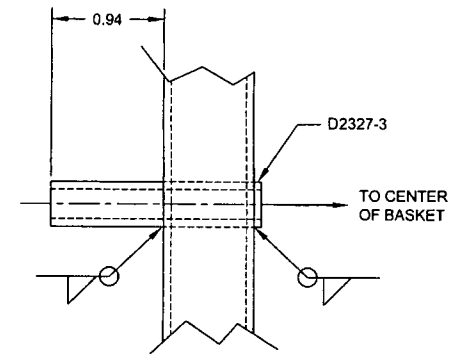
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DETAIL A B5-2
JOINT WELD DETAIL TYP
SCALE 2X

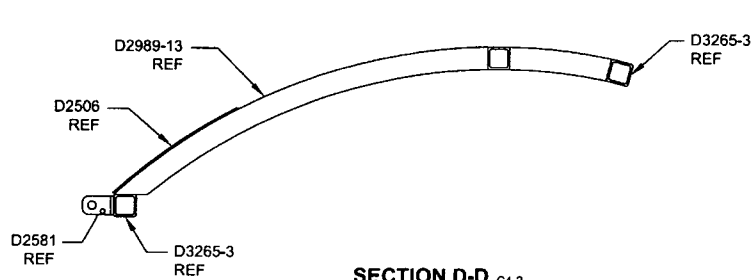


DETAIL B D2-2
2 PL
SCALE 2X

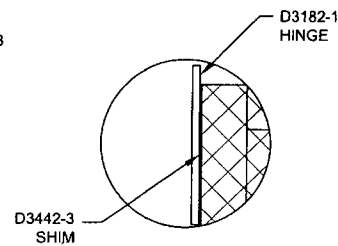


DETAIL C D5-2
SPACER INSTALLATION
SCALE 4X

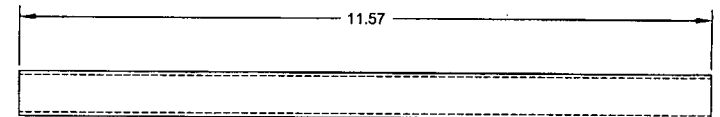
#56348



SECTION D-D C4-2



DETAIL E B6-2
SCALE 2X
2 PL



D3267-1 STRUT
SCALE 2X

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08-07-01/11/12

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DRAWN	AUS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
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